Qty:

Each

: BEARING CAP

: D312125

: N/A

: NIA

: 11/3/2006

: D3121 REV D

Date:

Thursday, 11/2/2006 1:15:52 PM

Chantal Lavoie

Process Sheet

Drawing Name

Part Number

Material

Due Date -

Drawing Number

Project Number

Drawing Revision

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

Estimate Number

: 29253 : 12412

P.O. Number

This Issue

Prsht Rev.

First Issue

: N/A

: 11/2/2006

S.O. No. : 1010

: NC

: WIA

Type : MACHINED PARTS

: 28092 **Previous Run**

Written By

: Est Rev:A New Issue 06-05-10 JLM

Checked & Approved By Comment

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MDELRINR12500

DELRIN ROUND BAR 1.25"



Comment: Qty.:

0.0546 f(s)/Unit Total:

1.6380 f(s)

Material: Ø1.25 Delrin Rod

(M-DELRIN-R1.2500) Identify as D3121-25

Batch: M/0/ 927

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHIN



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 57





PB 06/11/10

of objujal

Dart Aerospace Ltd

W/O:		WORK ORDER CH	ANGES	***			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:						
		·					
Part No	:	PAR #: Fault Category:	NCR: Yes	og /M	A: 🔛	Date: C	6/11/18

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto	
						-			
		· · · · · · · · · · · · · · · · · · ·							
			:						

NOTE: Date & initial all entries

Thursday, 11/2/2006 1:15:52 PM

User:

Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING CAP

Job Number: 29253

Part Number: D312125

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

7

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a doll-10

Dart Aerospace Ltd

Dait Ac	OSpaci	5 Llu							
W/O:			WO	RK ORDER CHAI	NGES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	-	PAR #:	Fault Categ	ory:					
		· · · · · · · · · · · · · · · · · · ·	NOBK OBDE	R NON-CONFOR			d:	Date:	
NCR:	,	V	VORK ORDE	R NON-CONFOR	IVIANCE (IVC	·K)			
DATE	STEP	Description of NC		· ····································	Section B	Verifi	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign Dat		ion C	Chief Eng	QC Inspector
	·					•			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

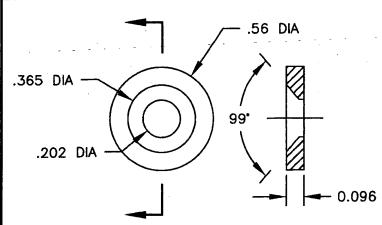
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	.3/3				
Ø1.000	+/-0.010	1.000				
Ø0.838	+/-0.002	.840				
R0.063	+/-0.010	,063	V			
R0.010	+/-0.010	-010	V			
0.230	+/-0.001	.231				
Ø0.865	+/-0.001	.864				
		,				
	•					

Measured by: J. MS	Audited by:	gnf	Prototype Approval:	N/A
Date: 06/11/08	Date:	06/11/08	Date:	N/A

Rev	Date	Change	·	Revised by	Approved
Α	04.04.20	New Issue	(P/O D3121-241)	KJ/RF	
В	06.06.09	Ø1.000 diamete	er was Ø1.024	KJ/JLM	

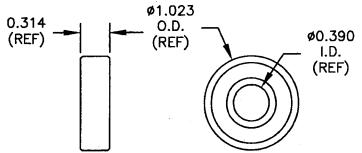


ſ	DESIGN 4	DRAWN BY	D/	ART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
ı	CHECKED	APPROVED AND	DRAWING NO.	RE	V. D
١	M. K.	H H	D3121	SHEET 10 O	F 10
ı	DATE		TITLE	· \$	CALE
	06.05.17		BRACKET	ASSEMBLY	1:1



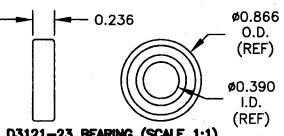
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

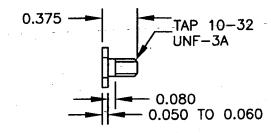
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

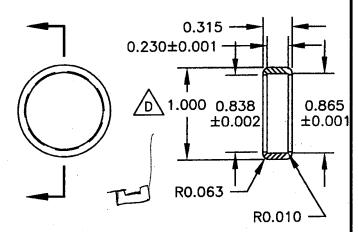
1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ

2) ALL DIMENSIONS ARE IN INCHES



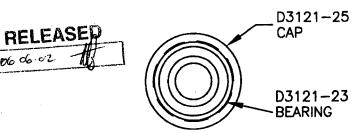
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25
 - (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-			
	. 1	·					
No.							

Part No: _		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
				QA: N/C	losed:	Date:

		WORK OR	DER NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B		Verification	Approval	
STEP	Section A Initial Action Description Chief Eng Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
			·				
					·		
		•					
	•						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Chief Eng Chi	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Chief Eng Chi

NOTE: Date & initial all entries